

Ship 18/02

Dart Aerospace Ltd.

Date: Monday, 2/4/2008 11:22:52 AM
User: Kim Johnston

Process Sheet

Split for 20

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY LOCK ASSEMBLY
Job Number	: 37148 - 1	Part Number	: D3393041
Estimate Number	: 10900	Drawing Number	: D3393 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 2/4/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: / / Type : MACHINED PARTS	Due Date	: 2/20/2008 Qty: 20 Um: Each
Previous Run	: 36070		
Written By	:		
Checked & Approved By	: <u>AS 08/02/04</u>		
Comment	: Est Rev: A New Issue 05-11-22 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D27287 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2728-7	Decal	B22554

AS 08/02/19 (x20)

2.0 D33731 Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3373-1 KA	Cam Lock	B23643 B23643

-20

AS 08/02/19 (x20)

3.0 516WC SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 5/16WC	SS Flat Washer	106731

AS 08/02/19 (x20)

4.0 D33931 Battery Lock Casing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3393-1	Battery Lock Casing	37149

AS 08/02/19 (x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 37148

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

37150

AS 08/02/19 (XAC)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

SB 08/02/19 (20)

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

SB 08/02/19

A/RN/A262 Locktite

M107045

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

SB 08/02/20

Key Numbers

1- A420

5- A420

9- A420

13- A420

17- A420

2- A420

6- A420

10- A420

14- A420

18- A420

3- A420

7- A420

11- A420

15- A420

19- A420

4- A420

8- A420

12- A420

16- A420

20- A420

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

M10524

FC 08/02/20 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 37148

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-20 (20)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body
9567K21 Batch: M17089 (2x)

M109/02 (384)

(20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-02-20 (18)

(P70)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST481

PC 8/2/20 (18)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.21

HA

Job Completion





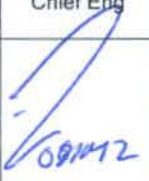
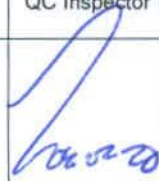
2008/2/20 (18)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	20.						

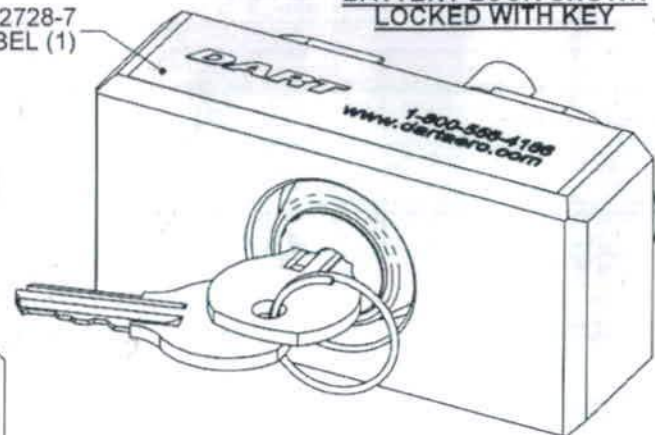
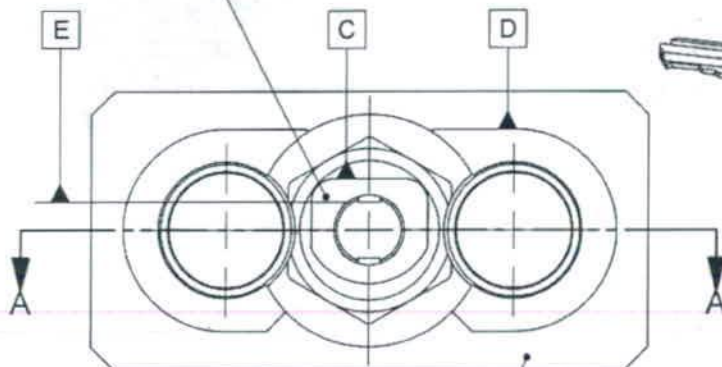
Part No: ~~3393~~ D 3393-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 37148		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.02.20	10.0	2 non conforming locks. 03393-3. see split-2		split w/o for qty 2 on - 2 : 18 on - 1	NIA	 08.02.20	 08.02.20	 08.02.20

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]
05/03/09D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1) $\varnothing 5/16"$ WC S/S
WASHER (2)

D3369-5 SPACER (1)

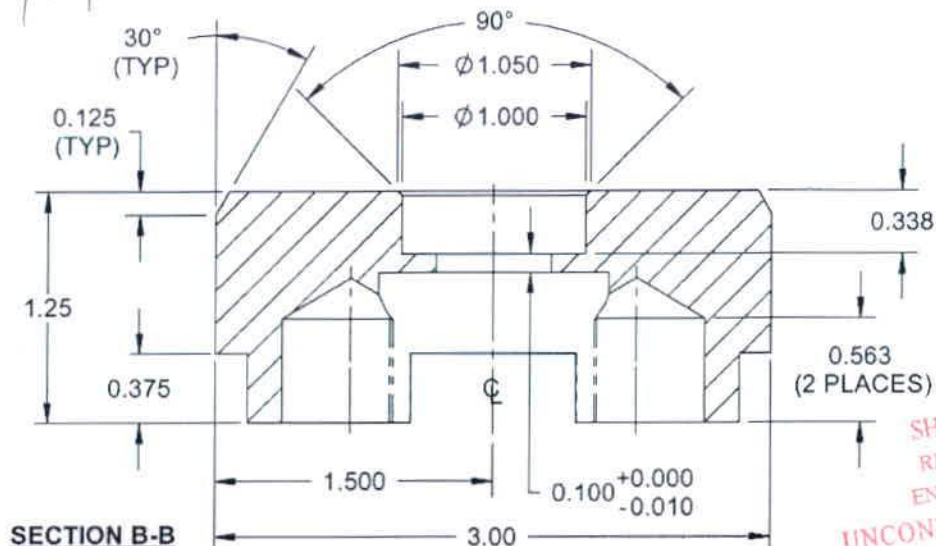
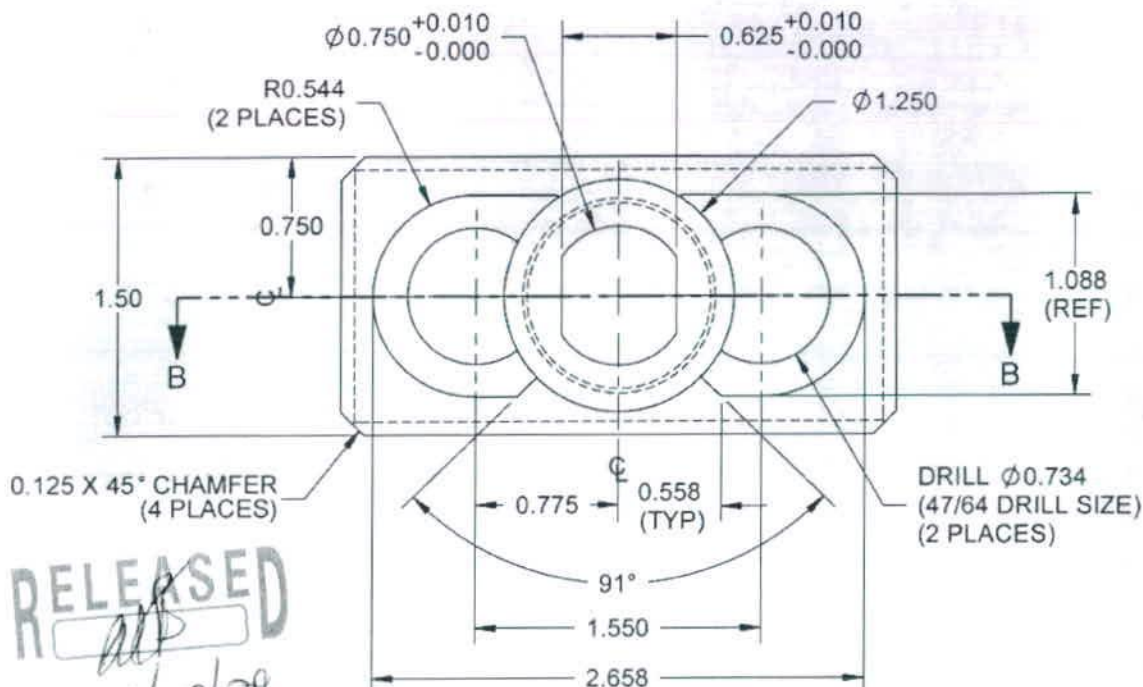
PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUED3393-3 CAM
LOCK SHAFT (1) $0.09^{+0.03}_{-0.01}$ (2 PLACES)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37148****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-Carr, P/N 9567K21

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CHECKED 13	APPROVED 13	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

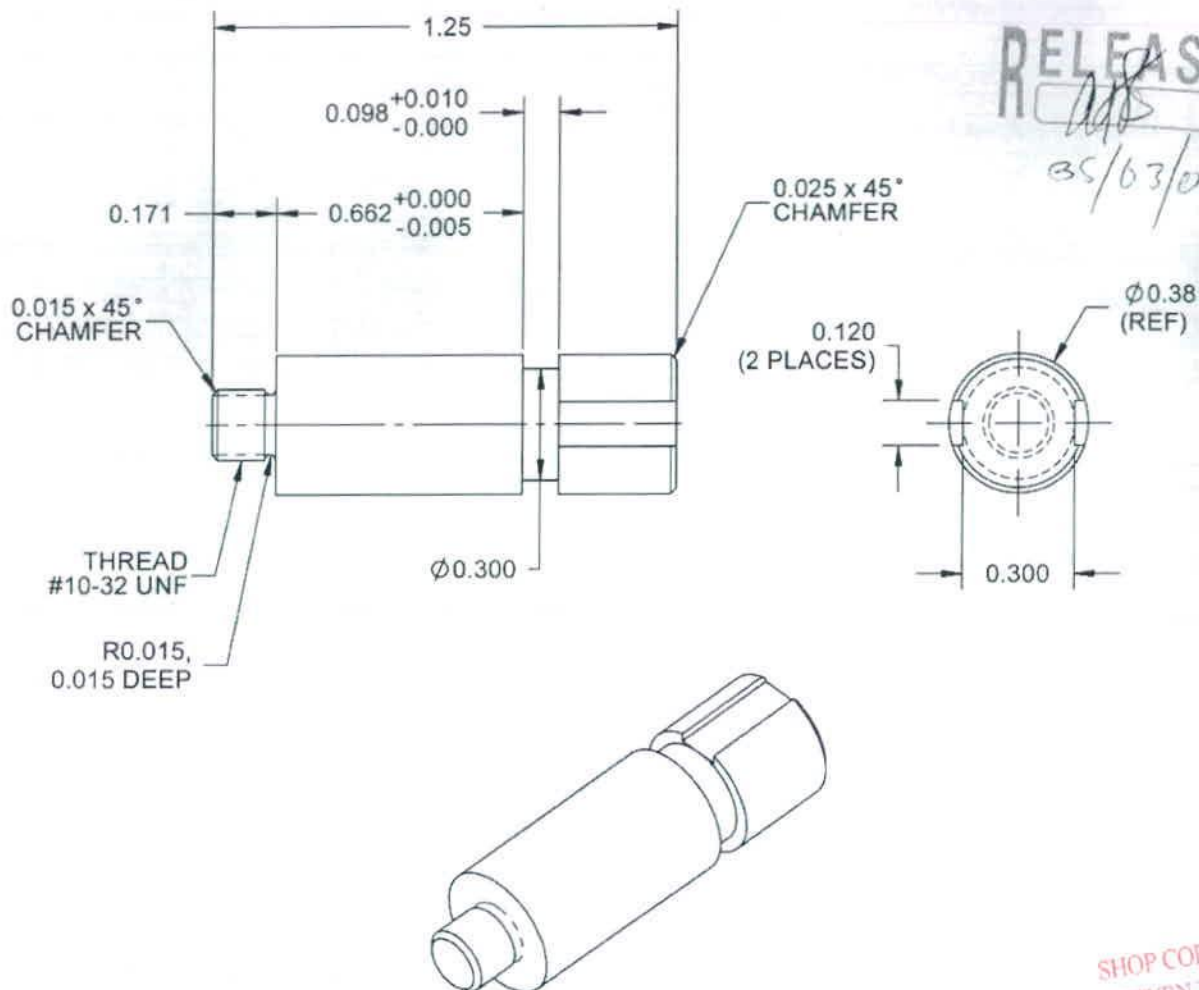
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NO. 37148

DART

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DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 37148

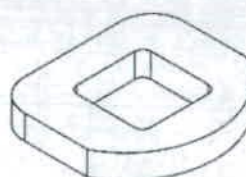
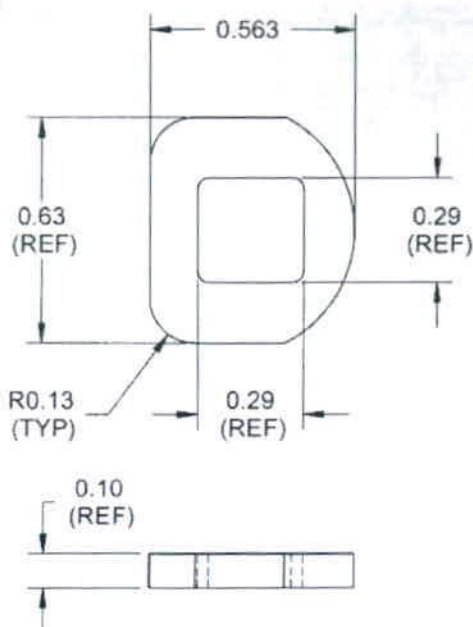
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/17

w/o 37148

- 5
D3369 SPACER

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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